

# Work Order ID 76545

**\*76545\***

Page 1

November-16-11 1:44:22 PM

Item ID: D4035-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lid Rib Assembly, Aft (350 Basket)  
 Start Date: 16/11/2011 Start Qty: 3.00 **\*3\*** Cust Item ID:  
 Required Date: 22/11/2011 Req'd Qty: 3.00 **\*3\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R S.S. rod Batch: M117884 0.00

**\*100\***  
 Large Fab Memo 0.00  
 Large Fab

- Memo
- 1- Cut D4035-3 as per dwg D4035
  - 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
  - 3- remove identification marks and deburr
  - 4- Weld bushing in rib and grind weld flush as per dwg D4035

PL 12.01.12 6X Ø

110 QC10- Inspect visual per QSI004- ground welds 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

5/12/11/13

46

# Work Order ID 76545

**\*76545\***

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

12/11/17  
 12-01-17

# Picklist Print

November-16-11 1:44:25 PM

Page 1

Work Order ID: 76545

**\*76545\***

Parent Item: D4035-043

**\*D4035-043\***

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 16/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9		Manufactured	No			100	Each	106.0000	2	812			
<b>*D4021-9*</b>										**			
Bushing													

Location	Loc Qty	Loc Code
WA	104	
70333	4	
72482	36	
74966	64	
WA005	2	
66437	2	

M304TS0.750W.049 Purchased No

**\*M304TS0 750W 049\***

304 SQ Tube .75x.75x.049W

100 f 578.4508 1.75 5.526316

\*\*

Location	Loc Qty	Loc Code
MAT018	553.6735839	
117775	93.6739	
118472	47.1990839	
118880	42.47	
119147	85.2606	
119643	285.07	
MAT034	1.8507	
117337	1.8507	
WA	22.92654	
118184	22.92654	

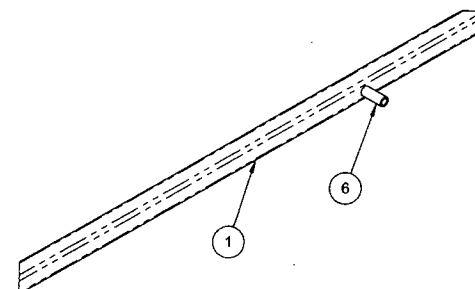
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10.5

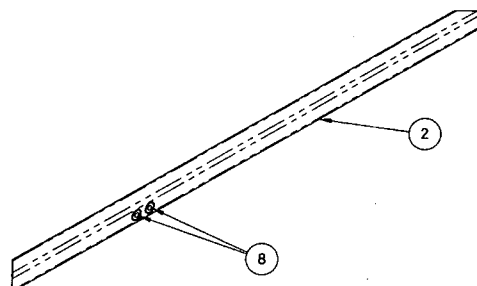
PL 12.01.12

PL 12.01.12

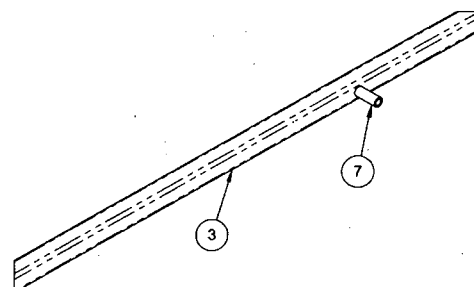
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



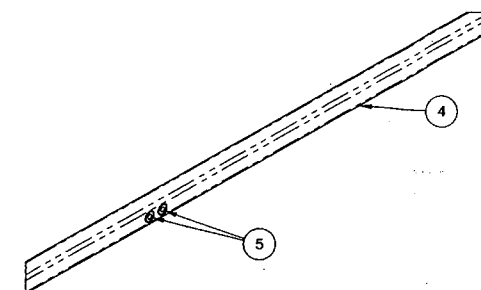
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76545 M.C.5  
11/11/16

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2010-03-12  
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A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
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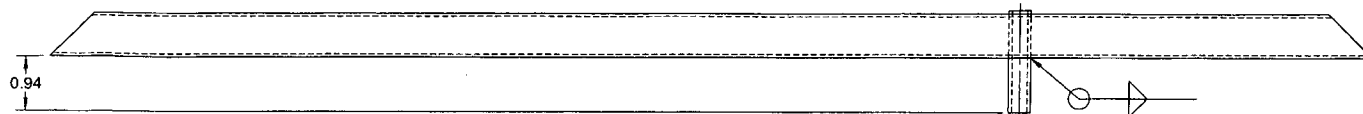
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR: Yes No** **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

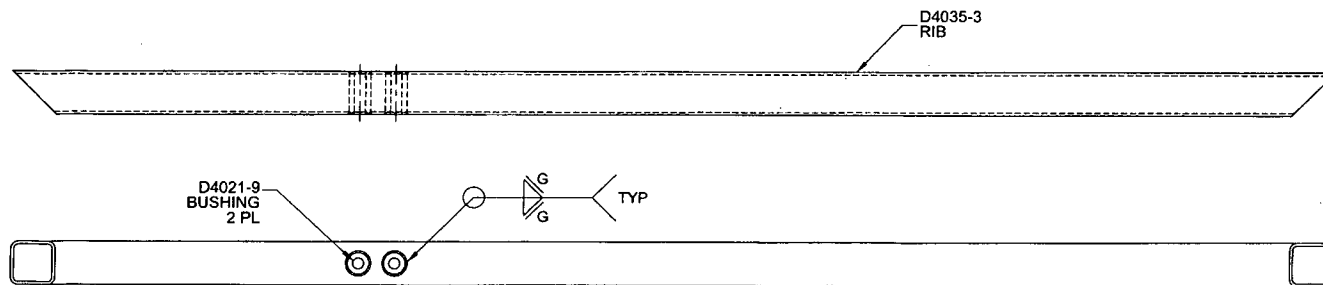
76548



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL





G  
G  
TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

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2010-03-12  
W.D.

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

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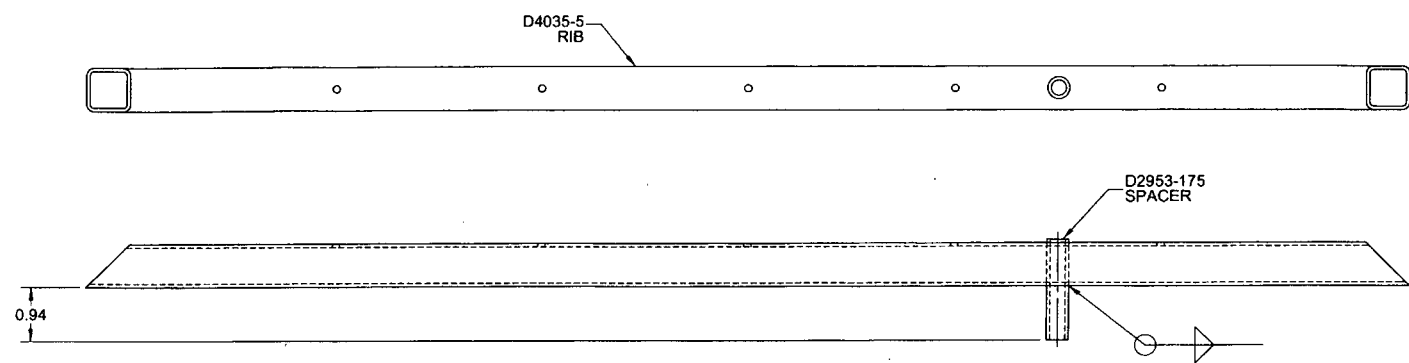
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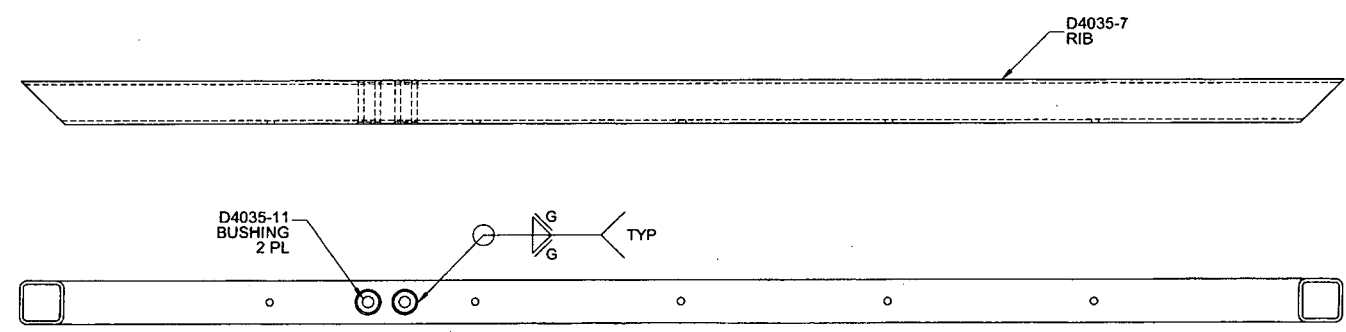
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.34 lbs
  - 8) WELDING: PER DART QSI 004

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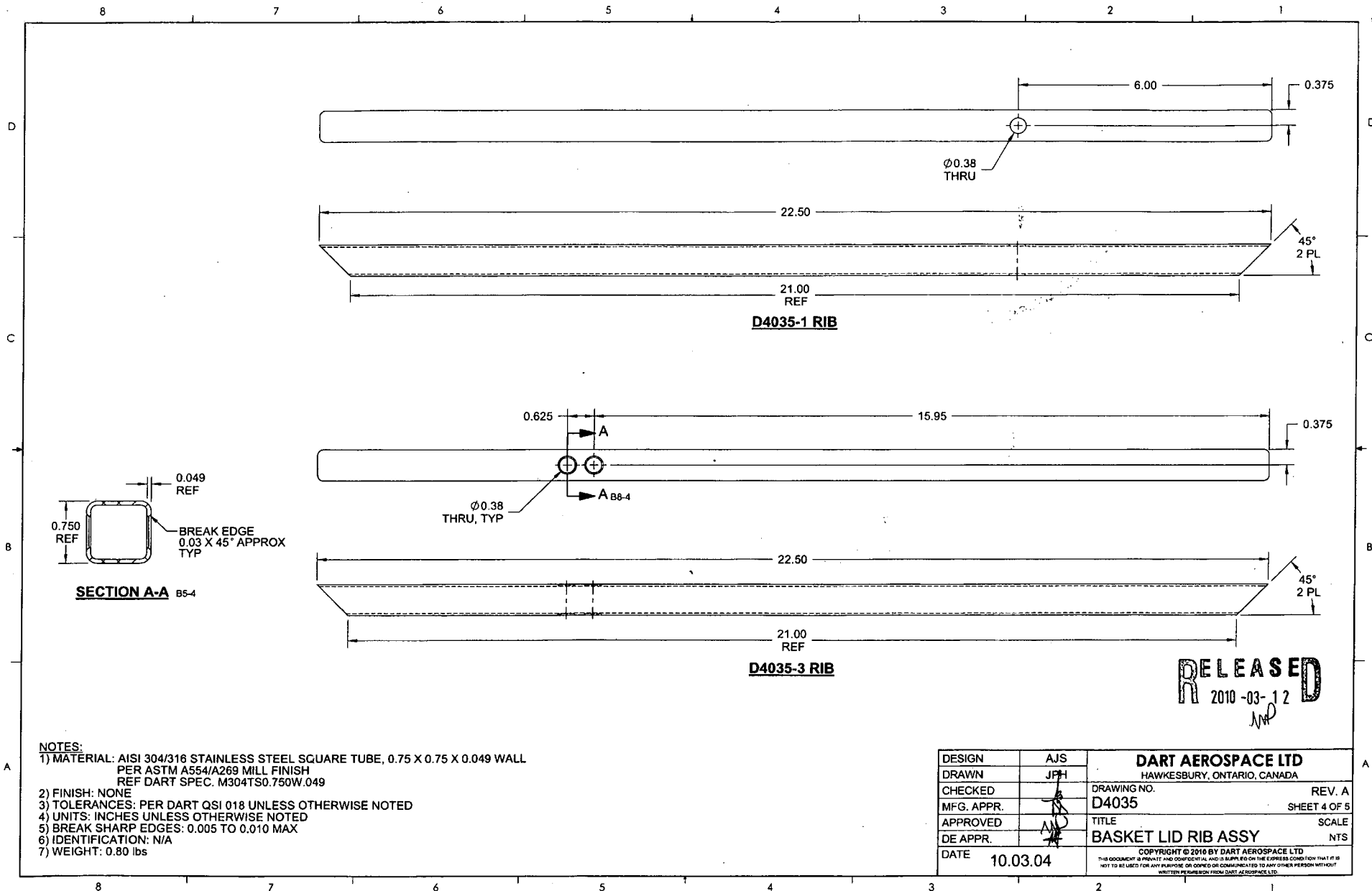
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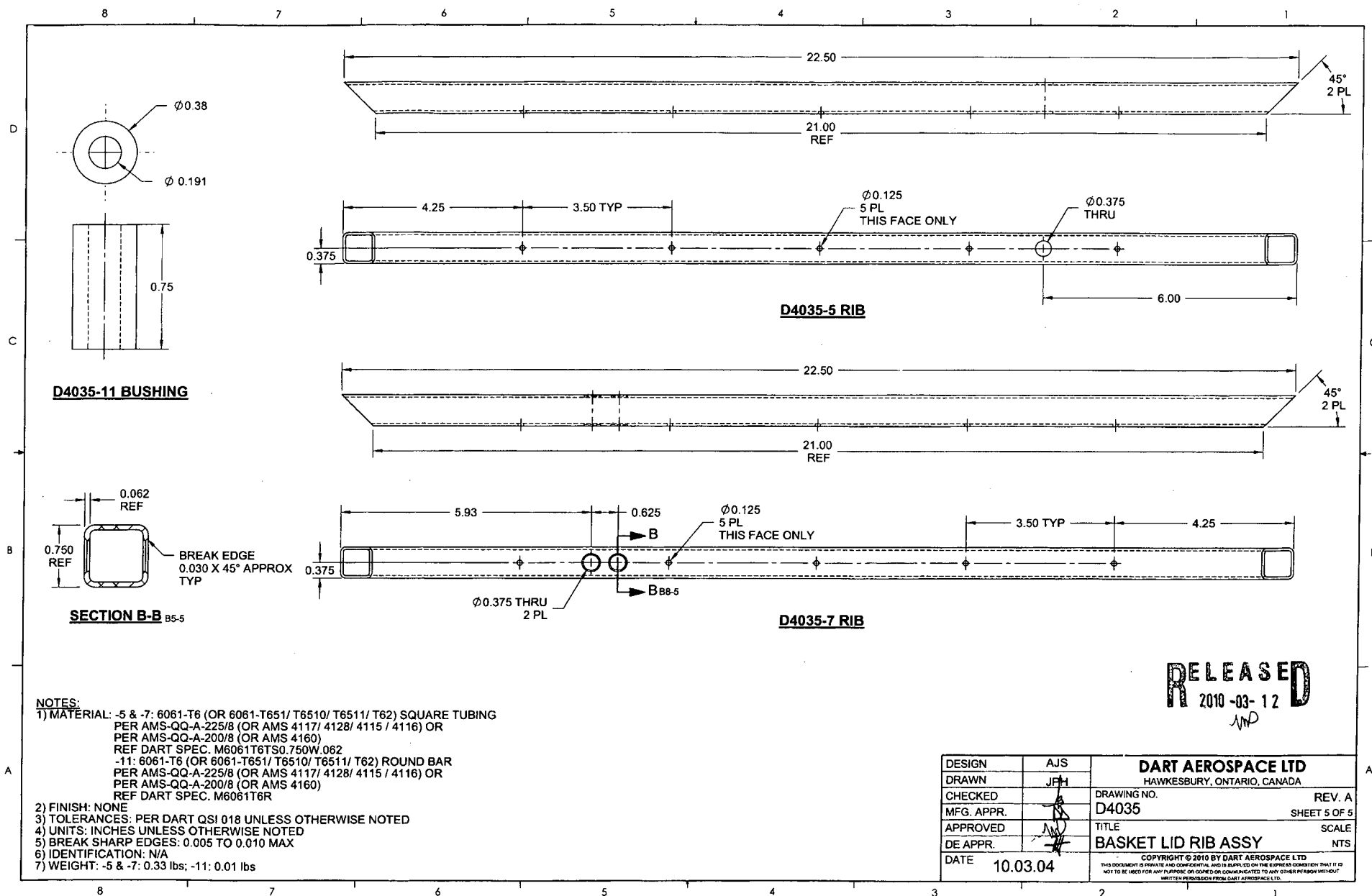
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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